



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5763-11

Job Sheet 207395

MAC
5/25/20

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Part No: D5763-11

Job Qty: 10 pcs

Part Name: Block

20 pcs



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/20

Job Tracking No:

Due Date: 3/6/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 2020-525 Was PN: 69830-07 DWG D5763 REVA IPP REV:A 19.12.19 NEW ISSUE JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	10 pcs	3/6/20	3/6/20	0.00	0.20	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		<i>MAC</i>
							Large Fab - 12		
110	QC 5	10 pcs	3/6/20	3/6/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S266183



Part: D5763-11

Job No: 207395

Serial No/Batch: S266183

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Date: 3/24/20

Plex 2/25/20 1:02 PM Dart.lajeunesse.marie

120 Packaging 3-1 - Stock - B4B 10 pcs

3/6/20 0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

130 QC 21 - SA

10 pcs

3/6/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

MAR 25 2020

Part Op 100 - 1- Cut as per D5763 DWG 2- Deburr

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Identify as per dwg & Stock Location: WA-004

130 - QC21- Final Inspection - Work Order Release

Job BOM

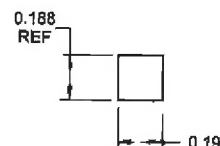
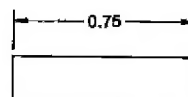
Part / Item	Component Name	Quantity	Operation	Container
M304B0.188X0.188	304 Bar, 0.188 X 0.188	.7410 ft (.0741 ea)	100-Large Fab - Welded Assy-1	5263536

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.188X0.188	1	0	0

Part Specifications

Specifications could not be found.



D5763-11 BLOCK
(DERIVED FROM AERO DESIGN P/N 69630-07)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR OR PLATE, 3/16 THICK
PER ASTM A276 OR ASTM A240 OR MIL-S-5058 OR AMS 5513 (304) OR AMS 5524 (316) OR ASME SA240
REF DART SPEC M304B OR M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

RELEASED

2020 FEB 19

UNDER REVIEW

URF 2020-524 20.02.20 (NO)

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. A
MF.G. APPR.	DD	D5763	SHEET 7 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	FWD BEAM	NTS
DATE	20.02.19	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045970



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 887 4248
Fax: 450 377 5698

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045970

PO Date: 2/27/20

Due Date: 3/13/20

Purchase Order

Revision:

Revision Date:

Issued By: Laviole, Chantal
Phone: 613-623-5200 Ext 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: quote no. SOU0243320

E-MAILED
MAR 2 2020

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M17-4-B1.250X2.000 ✓			17-4 SS Bar 1 250 x 2 00 MATERIAL 17-4 PH SS BAR AS PER AMS 6604/5643 GRAIN MUST BE ALONG LENGTH OF BAR MIN. YIELD TENSILE STRENGTH = 100 KSI MIN. ULTIMATE TENSILE STRENGTH = 150 KSI receive ft	Firmed -		3/13/20	12 ft	0 ft 12.5 ft PK	12 ft	\$95.08333/ft	\$1,141.00
2		M304B0 375X03 000 ✓			M304 SS bar 375 x 3 00 MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A278 OR ASTM A240 NOTE AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/5/20	12 ft	0 ft 12 ft	12 ft	\$11.335/ft	\$136.02
3		M304B0 188X0 188 ✓ LP			304 Bar, 0.188 X 0.188	Firmed -		3/5/20	12 ft	0 ft 12 ft	12 ft	\$1.29/ft	\$15.48

**ACIER QUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 MB: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 MB: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT

CO00194479

Billed to

DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Delivery Route 5

Customer N°

CLI0001056

Date

2020/03/02

Delivery date

2020/03/13

Your order N°

POHB045970

Processed by

Josianne Bourdon

Salesman

JOSIANNE BOURDON

Carrier

QUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Instruction F-M

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 PLATE SS 1 1/4 17-4 PH HS PSS-114174 10061 1 X 2" X 12' R/L POHB045970 LINE 1 HEAT: 92100404 AC34489-JO-11/03	106.45	2.00	PI2_\$CLB		1X 159"						
2 FLAT SS304 3/8 X 3 (R) FSS-383 3578 1 X 12' R/L POHB045970 LINE 2 HEAT: 10175797	45.96	12.00	PI_\$CLB		1x12'						
3 SQUARE SS 3/16 SS304 CSS-316 8678 1 X 12' R/L POHB045970 LINE 3 HEAT: 5R820	1.44	12.00	PI_\$CLB		1x12'						
4 FLAT SS304 5/8 X 3 FSS-583 9221 1 X 12' R/L POHB045970 LINE 4 HEAT: 54035 AC34489-JO-11/03	76.56	12.00	PI_\$CLB		1x12'						
5 SHEET SS 16G SS304-2B (4 X 8) DART FESSD-16G483042B 12463 6 X 4' X 8' POHB045970 LINE 5	504.00	192.00	PI2_\$CLB		6x4'x8'						

RECEIVED

MAR 13 2020

DART AEROSPACE LTD.

LINE 3

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304B 0.188 X 0.188

PO / BATCH NO.: P0413045970
5263536

DATE: MAR 17 2020

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 12 FT
QUANTITY INSPECTED: 12 FT
QUANTITY REJECTED: —

THICKNESS ORDERED: .188 X .188
THICKNESS RECEIVED: .188 X .188
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<input checked="" type="checkbox"/>	
CORRECT FINISH	<input checked="" type="checkbox"/>	N	
CORROSION	Y	<input checked="" type="checkbox"/>	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/>	N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/>	N	<u>ASTM A276</u>
CORRECT THICKNESS	<input checked="" type="checkbox"/>	N	
PHOTO REQUIRED	Y	<input checked="" type="checkbox"/>	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/>	N	<u>H/T 5RB20</u>
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/>	N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/>	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<input checked="" type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<input checked="" type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

Testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: <u>—</u>		
DATE: <u>MAR 17 2020</u>	DATE: <u>—</u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LINE 3

M 304 B 30.188 X 0.188

SPECIFICATION CONTROL DRAWING

△ PURCHASE MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
(NOTE: AISI 308 NOT ACCEPTABLE)

△ SPECIFICATION: ASTM A272 OR ASTM A240

PART NUMBER: M304B T T T T W W W W
THICK WIDTH

WHERE "T T T T" = THICKNESS IN INCHES
AND "W W W W" = WIDTH IN INCHES

△ EG. 0.5" X 3.0" BAR = M304B0.500X0.000
EG. 0.5" X 12.0" PLATE = M304B0.500X12.000

DAS
82
9-84

RELEASED
61 2010-11-30

C	ADDED PLATE TO PURCHASE MATERIAL. ADDED PLATE RELATED SPECIFICATIONS AND EG. CHANGED TITLE FROM "M304B BAR" TO "304/316 BAR/PLATE"	MB	10.11.25
B	REFORMAT DWG ACC. SPEC'S (EN 06-1) REF PAR 08-020A	LP	09.07.15
A	NEW ISSUE	PH	05.06.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO
M304B

TITLE
304/316 BAR/PLATE

REV C
SHEET 1 OF 1

SCALE
NTS

COPYRIGHT © 2005 BY DART AEROSPACE LTD
THIS DRAWING IS A UNCLASSIFIED AND IS TO BE USED BY THE PURCHASER FOR THE
PURPOSES OF THE PURCHASE OF THE PARTS AND MATERIALS ONLY. IT IS NOT TO BE
REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR
MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION
STORAGE AND RETRIEVAL SYSTEM.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/> </div> </div>		
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Follo/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>		
Other/Details:				